

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012239**Date Inspected:** 20-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Trial Assembly Area

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 7AE to 7BE, weld No.OBE7B-004. The welder is identified as #037743. ZPMC QC is identified as Mr.Shen Jian Bo. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 4G position for the OBG Segment 7AE to 7BE, weld No.OBE7B-005. The welder is identified as #066038. ZPMC QC is identified as Mr.Shen Jian Bo. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

SMAW in the 3G position for the OBG Segment 7AW to 7BW, weld No.SP429-001-031. The welder is identified as #068917. ZPMC QC is identified as Mr.Li Yang. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

During Quality Assurance random in-process observations of the fabrication of crossbeam CB6, this Quality Assurance inspector (QA) discovered that the Base metal repairs being performed on Seismic Performance Critical

WELDING INSPECTION REPORT

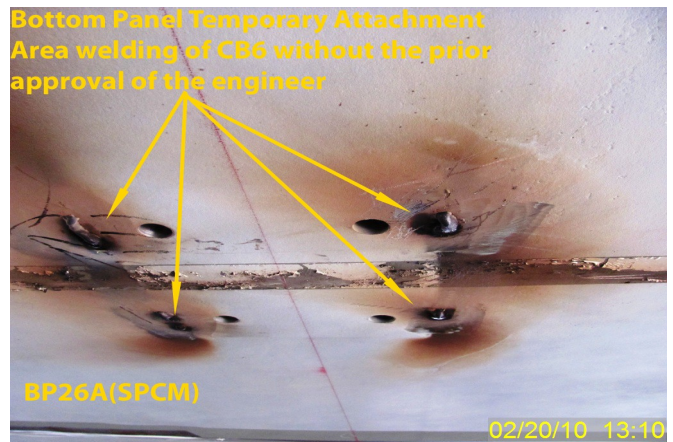
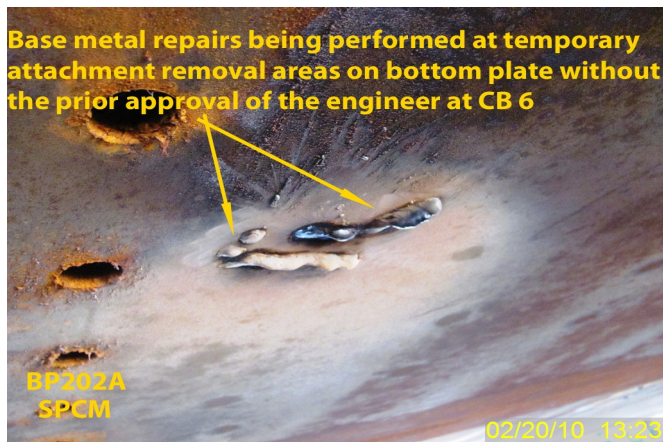
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Members (SPCM) without Engineers approval. The repairs are being performed at temporary attachment removal sites on the bottom panels, at the north and south ends of the crossbeam as well as the bottom panels of the FL3 floor beams in the area of the splice plates. Base metal repairs were also being performed at all of the traveler rail bracket connection areas of CB6. ZPMC Quality Control Inspector (QC) provided this QA with Critical Weld Repair (CWR) report identified as B-CWR-1098, which does not mention any of the above mentioned panels. The bottom panels of the crossbeam as well as the FL3 bottom panels are designated on the approved shop drawings as Seismic Performance Critical Members (SPCM). The bottom panels for the FL3 floor beams are identified as BP25A (segment 6CE) and BP26A (segment 6CW).

The bottom panels for CB6 are identified as BP201A, BP202A, BP203A, BP204A and BP205A.

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Bera,Subhasis | Quality Assurance Inspector |
| Reviewed By: | Patterson,Rodney | QA Reviewer |
